

split

Date: Thursday, 9/20/2007 3:23:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 34749		
Estimate Number	: 10531		
P.O. Number	: <i>N/A</i>	Part Number	: D2572
This Issue	: 9/20/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2572 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: E
Previous Run	: 34368	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/1/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>4</i> (10) Um: Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: *B31388*

S.F. 07/10/17

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. *S.F. 34749* Double check by: *[Signature]*
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

S.F. 07/10/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

S.F. 07.10.21 (4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.F. 07.10.21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/23		split up	u		4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:29:10 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 34749

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/24 (4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-k 07/10/25

(4X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068

M-k 07/10/25

(4X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M1

07-10-25

(4X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

07/10/26

AS (4X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

N 07/10/26

Job Completion



u 07-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34749
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	.441	.441	.441		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.499	3.499	3.498	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.749		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.500	.500	.502	.507		
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	DT8684	.377	.377	.377	.375		
I	0.490	0.510		.500	.501	.510	.501		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.568	.569	.578	.568		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.500		
N	2.495	2.505		2.500	2.500	2.501	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.124	.122	.122	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.250		
S	0.115	0.135		.134	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.967	2.962		
V	0.230	0.250		.241	.240	.235	.240		
W	0.115	0.135		0.130	.130	.135			
X	0.307	0.312		0.312	.312	.312	.312		
Y	0.760	0.765		0.760	.760	.760	.760		
Z	0.352	0.372		0.366	.366	.366			
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.627	.627	.627			
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.383	1.386	1.397	1.390		
AF	0.115	0.135		.135	.135	.131	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.001	2.003		
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	S.F.
Date:	07/10/18

Audited by:	J.F.
Date:	07/10/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	34749
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443	DT8682	.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.005	8.005	8.005		
F	0.490	0.510		.500	.507	.507	.507		
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.505	.504	.504	.505		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.254	.254	.250		
S	0.115	0.135		.125	.126	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.130	.125	.125	.125		
X	0.307	0.312		.310	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.350	.355	.355	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.388	1.388	1.388	1.388		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.003	2.002	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	SP
Date:	07/10/21

Audited by:	J.F.
Date:	07/10/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 34749
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

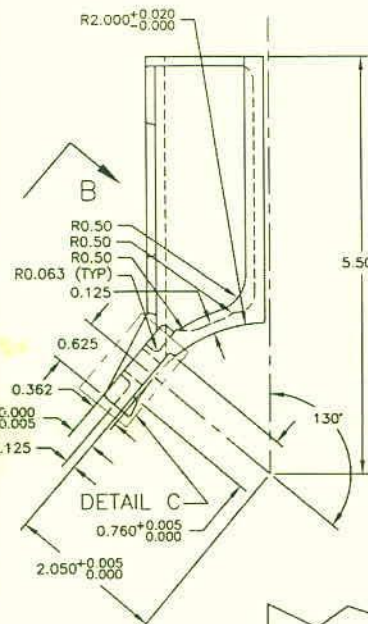
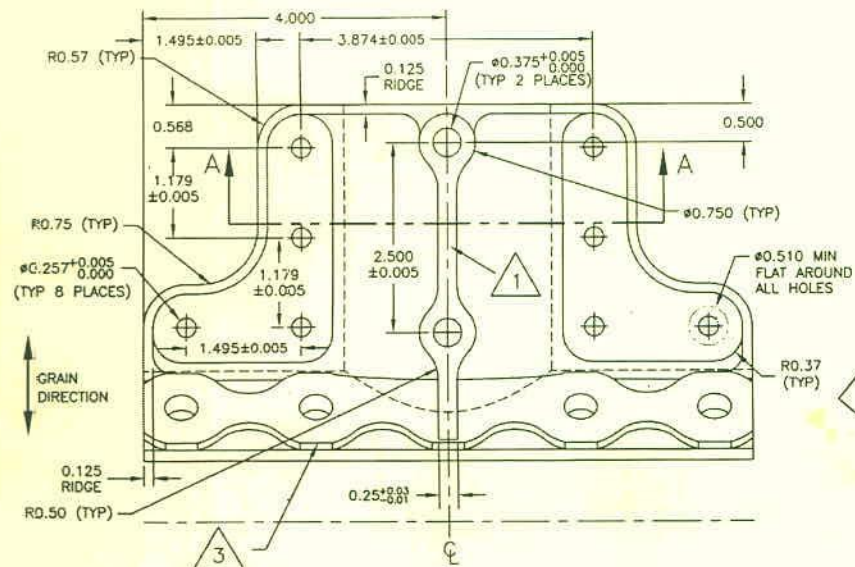
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.005	8.005				
F	0.490	0.510		.503	.503				
G	0.257	0.262	DT8683	.257	.258				
H	0.375	0.380	DT8684	.375	.376				
I	0.490	0.510		.505	.505				
J	1.174	1.184		1.180	1.179				
K	0.558	0.578		.566	.568				
L	1.174	1.184		1.180	1.179				
M	1.490	1.500		1.500	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.122				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.962	2.962				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.122	.122				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		.762	.762				
Z	0.352	0.372		.362	.362				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.630	.630				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.387	1.387				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.249	.249				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: J.P.
Date: 02/10/22

Audited by: J.F.
Date: 07/10/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

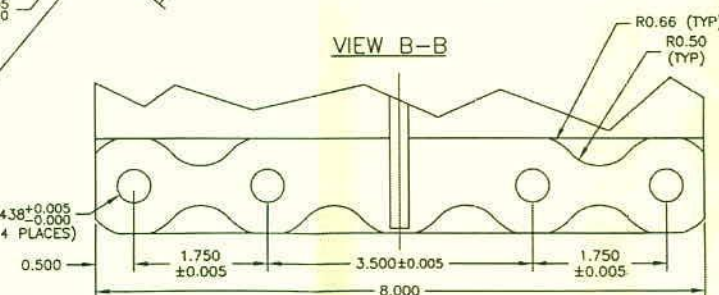
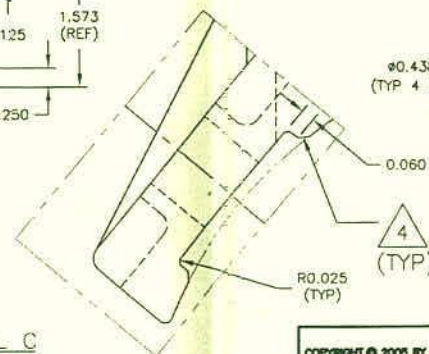
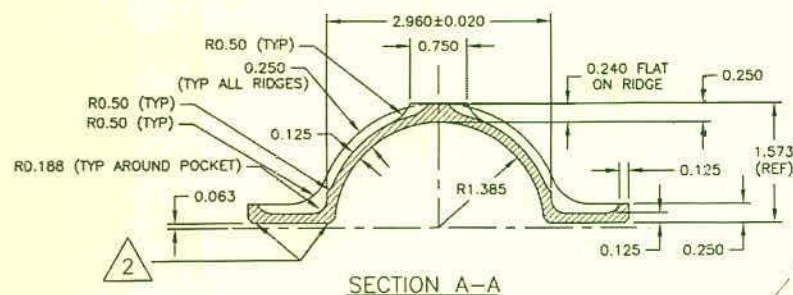
05.12.06 ~~11~~






NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 3 | CHAMFER 0.063 x 45° ALL AROUND |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. JEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		
CHECKED	APPROVED	
		DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
DATE 05.07.13		DRAWING NO. D2572
		TITLE INNER FWD SADDLE
		REV. 1 OF 2
		SCALE

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DART AEROSPACE LTD.

DART DART AEROSPACE LTD.
HARVEY, ONTARIO, CANADA

DRAWING NO. D2572	REV. 1 SHEET 1 OF
TITLE INNER FWD SADDLE	SCALE 2:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34749

DETAIL C
SCALE 2:1

2141

NEW YORK CITY
JULY 1890